

Work Order ID 86025

86025

Page 1

Item ID: D4148-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug Assembly, Fwd **7x**

Start Date: 19/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: **MLJ**

Date: **12/06/20** Tooling:

Date:

Run Start ***NR1***

QC: _____

Date: _____ SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	D								
100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: SI 468	0.00							
120									
Packaging	Memo	0.00							
Packaging									

7x

12/07/20

(+7)

8.26.10.3

7x

12-7-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86025

June-19-12 4:05:23 PM

86025

Page 2

Item ID: D4148-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 19/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/7/5 JF

MF

12-07-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-19-12 4:05:26 PM

Page 1

Work Order ID: 86025

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

86025

D4148-041

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
 IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP Rev:C
 10.10.29 as per revC DD verf:EC IPP REV:D 11.03.02
 AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			100	Each	1,319.000	4	8			
MS21043-3									**				
Nut													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		72							
				103691		72							
				ST301		1247							
				118077		2							
				118614		51							
				118686		30							
				119758		20							
				121255		188							
				121708		956							
MS21043-4		Purchased	No			100	Each	1,094.000	1	12			
MS21043-4									**				
Nut													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		40							
				104603		40							
				ST301		1054							
				119546		115							
				121162		439							
				121652		500							

EP 12/07/03

EP 12/07/03

21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 86025

86025

Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

D2690-6

Manufactured No

100

Each

6.0000

1

4

D2690-6

Lanyard Assembly

**

Location

Loc Qty

Loc Code

ST014

6

83360

6

D3910-1

Manufactured No

100

Each

31.0000

1

4

D3910-1

Crosstube Lug

**

Location

Loc Qty

Loc Code

st507

31

81474

2

81573

29

D4091-1

Manufactured No

100

Each

66.0000

1

4

D4091-1

Mounting Lug

**

Location

Loc Qty

Loc Code

ST458

66

81168

26

81575

40

D4148-1

Manufactured No

100

Each

30.0000

2

8

D4148-1

Crosstube Lug Plate, Fwd

**

Location

Loc Qty

Loc Code

ST101

30

83421

10

85753

20

EP 12/07/03
385757
(40)

EP 12/07/03

EP 12/07/03

EP 12/07/03

10
4

June-19-12 4:05:27 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 86025

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

86025


D4148-041

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

 D4148-3
D4148-3
Stud Receiver, Lower

Manufactured No

100 Each 2.0000 1 4

**

EP 12/07/03
385754 (52)

D4148-5

D4148-5

Eyebolt Stud

Manufactured No

100 Each 7.0000 1 4

**

EP 12/07/03

AN3C12A

AN3C12A

Bolts

Purchased No

100 Each 225.0000 2 8

**

EP 12/07/03

Location

ST101
83356

Loc Qty

2
2

Loc Code

Location

ST102
84196

Loc Qty

7
7

Loc Code

Location

GA
120449
ST351
117514
118112
118451
119510
120423
121259
121584
121689

Loc Qty

38
38
187
4
5
22
1
51
4
50
50

Loc Code

14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

June-19-12 4:05:27 PM

Page 4

Work Order ID: 86025

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

86025

D4148-041

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

AN4C13A Purchased No

AN4C13A

BOLT

MS17984-C413

Purchased

No

MS17984-C413

PIN, QUICK RELEASE

MS20615-4M18

Purchased

No

MS20615-4M18

Rivet

NAS1149C0332R

Purchased

No

NAS1149C0332R

Washer

100 Each 44.0000 3 12

**

Location

Loc Qty

Loc Code

ST357

44

120187

1

121827

43

100 Each 17.0000 1 4

**

Location

Loc Qty

Loc Code

ST315

3

114340

1

118612

2

ST333

14

121350

14

100 Each 33.0000 8 32

**

Location

Loc Qty

Loc Code

322

3

121349

3

ST322

30

121444

30

100 Each 9,782.000 4 16

**

Location

Loc Qty

Loc Code

297

9782

122063

9782

EP 12/07/03

M 122141 (21x)
EP 12/07/03

7
EP 12/07/03

M 122141
(56x)

EP 12/07/03

28

June-19-12 4:05:27 PM

Shop Packet Print

Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 5

Work Order ID: 86025

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

86025

D4148-041

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0432R

Purchased

No

100

Each

3,718.000

6

24

NAS1149C0432R

Washer

**

EB 12/07/03

Location

Loc Qty

Loc Code

ST297

1070

117291

70

119124

1000

ST298

2648

121255

2648

42

June-19-12 4:05:27 PM

Shop Packet Print

Page 5

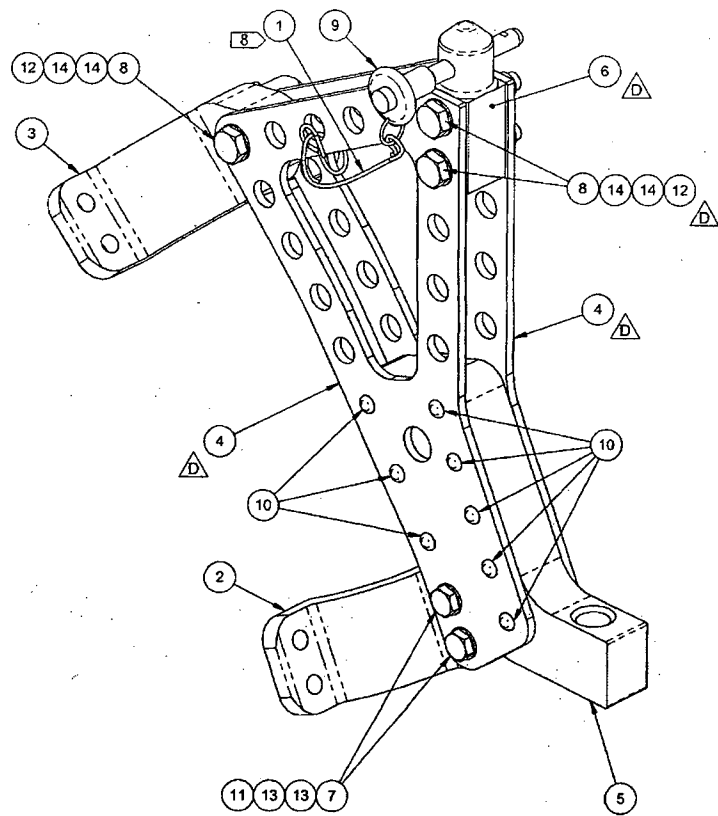
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.67 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *86025 MJS*
12/06/20

ITEM	QTY	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

RELEASED
2011-02-24

D	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.260" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4148** REV. D
SHEET 1 OF 5
TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

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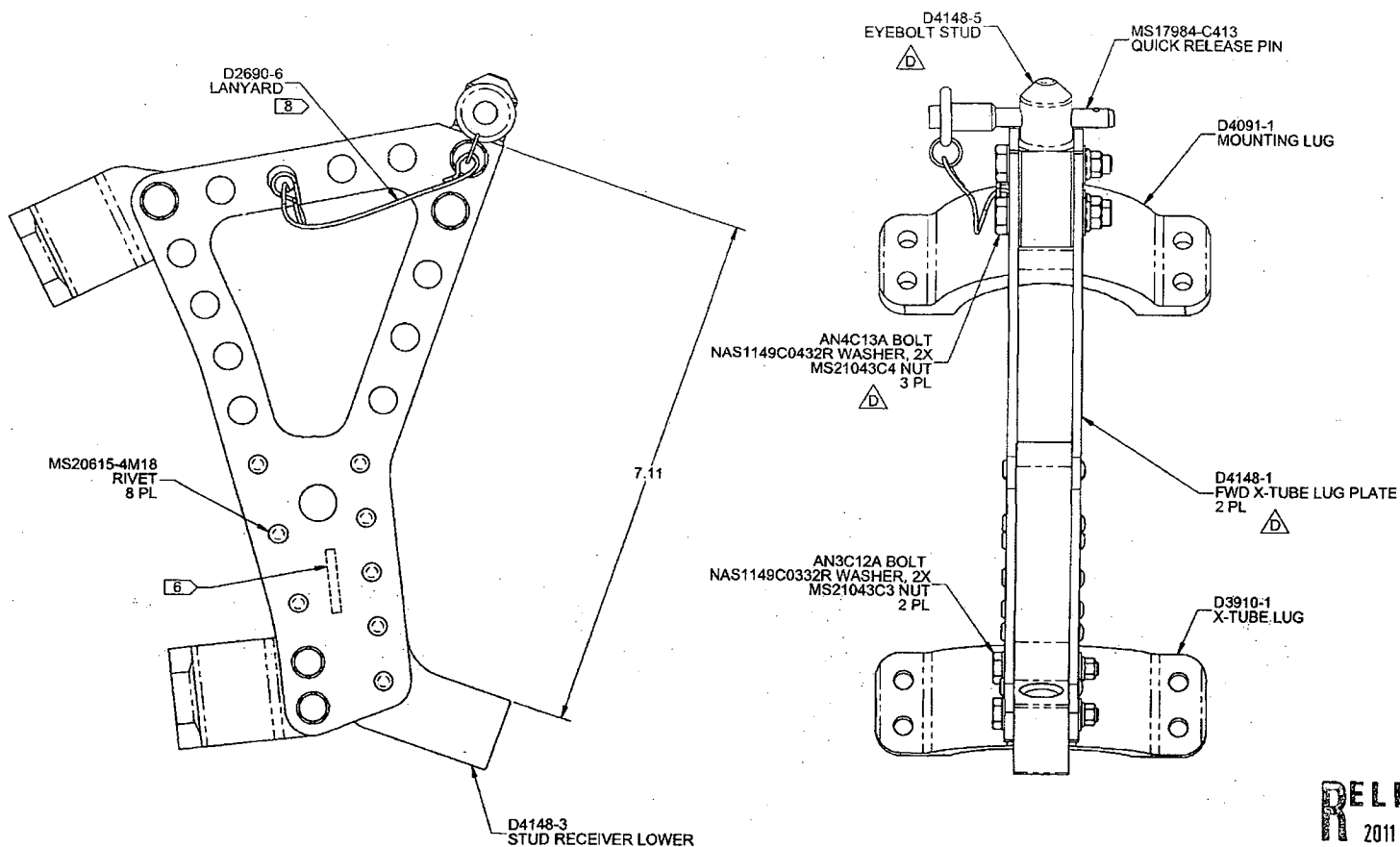
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

RELEASED
2011-02-24
JMP

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	REV. D
MFG. APPR.	JMP	D4148	SHEET 2 OF 5
APPROVED	JMP	TITLE	SCALE
DE APPR.	JMP	FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS TO BE SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

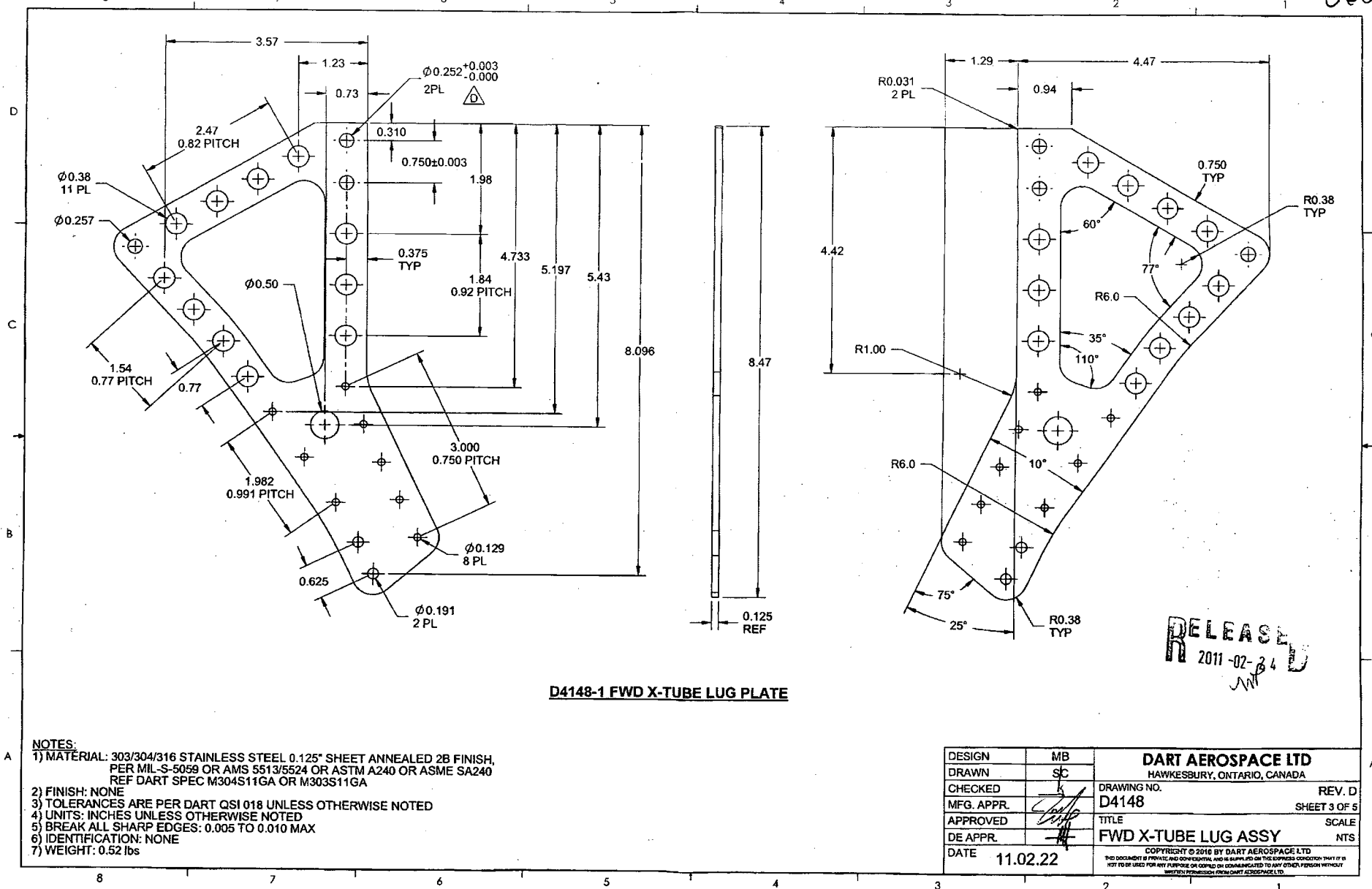
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NOTE: Date & initial all entries

86025



D4148-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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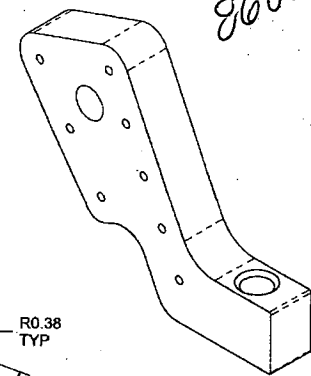
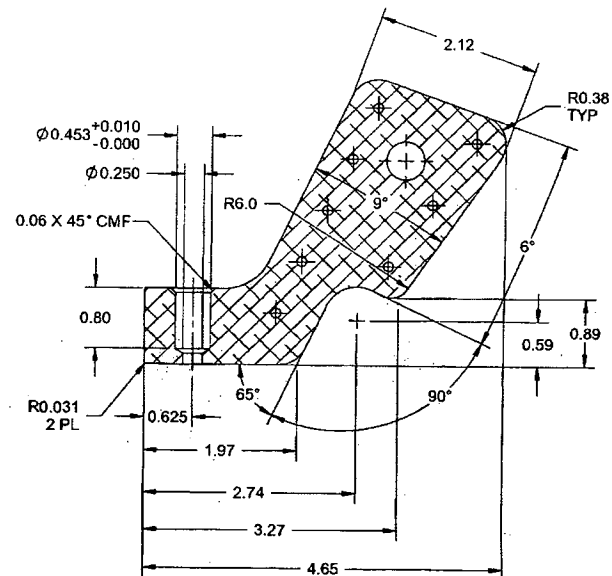
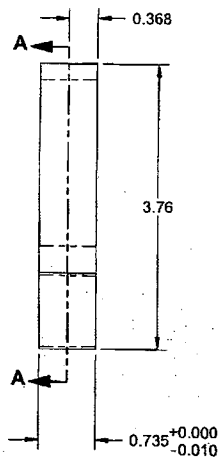
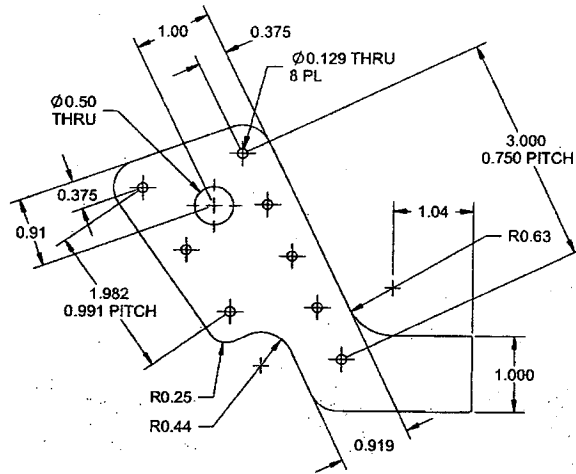
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NOTE: Date & initial all entries



D4148-3 STUD RECEIVER LOWER

SECTION A-A

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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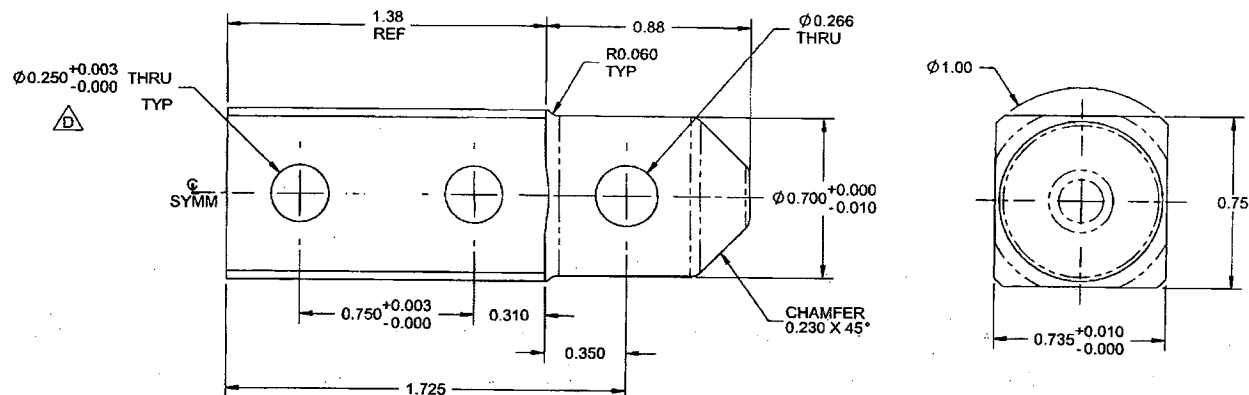
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NOTE: Date & initial all entries

86025



D4148-5 EYEBOLT STUD

RELEASED
2011-02-22

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries